

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

1. (Currently Amended) A method of forming a headliner for a vehicle, comprising:

overlays a cover material onto a **multi-layer** substrate;

at least partially separating the cover material from the substrate during said overlaying step;

clamping the cover material;

clamping the substrate separately from the cover material;

transporting the overlayed cover material and substrate into a mold;

unclamping the substrate while the cover material remains clamped; and

molding the cover material and substrate together to form the headliner.

2. (Original) The method of claim 1, wherein said step of clamping the cover material comprises using a jaw clamp to hold the cover material, and said step of clamping the substrate comprises using a plurality of discrete clamping members to clamp the substrate.

3. (Original) The method of claim 2, wherein each said discrete clamping member comprises a pneumatically actuated pin member.

4. (Original) The method of claim 2, wherein said jaw clamp comprises a pivotable structure including a plurality of teeth.

5. (Original) The method of claim 1, wherein clamps used for said clamping steps are movable for said transporting step.

6. (Original) The method of claim 1, wherein said step of at least partially separating comprises providing at least one separator plate along an edge of the cover material between the cover material and the substrate.

7. (Original) The method of claim 6, wherein said separator plate includes a movable portion to facilitate cutting of the cover material and substrate.

8. (Original) The method of claim 1, further comprising unclamping the cover material after unclamping the substrate.

9. (Original) The method of claim 2, further comprising selectively unclamping said discrete clamping members at different times.

10. (Canceled)

11. (Canceled)

12. (Canceled)

13. (Canceled)

14. (Canceled)

15. (Canceled)

16. (Canceled)

17. (Canceled)

18. (Canceled)

19. (Canceled)

20. (Canceled)

21. (Canceled)

22. (Canceled)

23. (New) The method of claim 1, wherein the substrate comprises multiple layers.